

Work Order ID 46409-4 split

June 26, 2009 11:50:47 AM



Item ID: D6101-001
Revision ID: A
Item Name: Saddle Billet

Accept



Setup Start



Stop



Start Date: 15/07/2009 Start Qty: 300.00
Required Date: 03/08/2009 Req'd Qty: 300.00

150
200



Cust Item ID:
Customer:

Reference:

Run Start



Stop



Approvals: Process Plan: CY
QC:

Date: 09/10/28 Tooling:

Date:

Date: SPC (Y/N):

Date:

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D6101	Rev A								
100	PURCHASING	0.00							
Purchasing	Memo	0.00							
Purchasing	Issue P/O: 8363 a)Description: Alluminum billet b) 6.00" x 6.250" x 2.00" thick c) Tolerance on length are +0.025"/-0.000" A: +/-0.008" d) Grain direction along 6.00" length e) Material: 7075-T7351 (QQ-A-250/12) f)Material certification required								
110	Receive & Inspect for Damage & Mat'l Certs	0.00							
Packaging	Memo	0.00							
Packaging	Ensure material certification is attached								

CY 09/10/23

09/10/23 (40)

Work Order ID 46409

June 26, 2009 11:50:47 AM

Item ID: D6101-001

Revision ID: A

Item Name: Saddle Billet

Start Date: 15/07/2009 Start Qty: 300.00

Required Date: 03/08/2009 Req'd Qty: 300.00

Reference:

Approvals: Process Plan:

QC:

Sequence ID/
Work Center ID

120



QC

Quality Control

Operation
Description

QC6- Inspect dimensions to drawing

Memo

Ensure Material certification comply to Dwg D

Set Up/
Run Hours

0.00

0.00

0.00

0.00

0.00

0.00

Accept



Tooling:

SPC (Y/N):

Cust Item ID:

Customer:

Date:

Date:

Draw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Setup Start

Stop

Run Start

Stop

Identify as per dwg & Stock Location: Mst

Memo

QC21- Final Inspection - Work Order Release

Memo

inf 09/10/24

inf 09/10/24

09.10.28

40

40

H0910-24
(40)

Picklist Print

June 26, 2009 11:29:29 AM

Work Order ID: 46409

Parent Item: D6101-001RevA

Parent Item Name: Saddle Billet

Comments:

Component Item ID/
Item Name

Replacement
Item ID

Mfg/
Purch

Purchased

D6101-001PRevA



7075-T7351 2X6X6.25



Start Date: 15/07/2009

Start Qty: 300.00

Required Date: 03/08/2009

Required Qty: 300.00

Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued
No			110	Each	0.0000	300.0000	



Date
Issued

Status

12/9/123 (40)

**Castle Metals®**

A. M. Castle & Co.

PACKING SLIP

Page 1 of 1

Pack Slip No:4567834

Ship From: Castle Metals MONTREAL 835-SELKIRK AVENUE POINTE CLAIRE, QUEBEC H9R 3S2		Sold To: DART AEROSPACE LTD 1270 ABERDEEN HAWKESBURY, ON K6A 1K7		Ship To: DART AEROSPACE LTD 1270 ABERDEEN HAWKESBURY, ON K6A 1K7		Deliver To: DART AEROSPACE LTD 1270 ABERDEEN HAWKESBURY, ON K6A 1K7 CA	
Date Shipped 21-OCT-09	F.O.B. ORIGIN	Freight Terms Prepaid		Carrier MANITOULIN	BOL No 99185-2	Delivery No 4567834	

Shipment Details	Final Destination Branch - MON
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Order No 324263	Line No 1	Item No 6857.MO	Description 2.0000.PL.7075.T7351.ALUMINUM.48.5000.144.5000 CUT 2SIDED TO 6.25 IN (+ .0310/- .0000 IN (GRAIN TO RUN ALONG 6")) X 6 IN (+ .0310/- .0000 IN (GRAIN TO RUN ALONG 6")) - ALUMINUM PLATE SAW			
Purchase Order No 8393		Part Number		Ordered Qty 40 PCS	Invoice Qty 40 PCS	Backorder Qty
Details		R2C SEE FRANCE STATUS				
Mill	Heat Number 456750A9	Mech Id	PCS 40	Width (IN)	Length (IN)	Shipped Qty (LBS) 303.16

These commodities/technologies are subject to US Export Administration & US State Dept. Regulations and, if intended for export, were/are exported thereunder. Diversion contrary to US Law is Prohibited.

We hereby certify the material covered by this certification conforms in accordance with the above specifications and has been found to meet the applicable requirements for the material, including any specifications forming a part of the description. Test reports are on file subject to examination. All claims for defective material are waived unless made in writing to A.M. Castle & Co. within 60 days of the shipment. Material cut to the correct size, or material cut by the customer cannot be returned for credit.

This material has been received and inspected by:

Date:

**KAISER
ALUMINUM**Trentwood Works - Spokane, WA 99215
Phone: (800) 367-2586**CERTIFIED TEST REPORT**Serial Number
4149447

Lot: 456750A9 Cast 198 Drop 20 Ingot 1

(ASTM B8/B667)

Tensile:	Temper	Dir / # Tests	Ultimate KSI (MPA)	Yield KSI (MPA)	Elongation %
	T7351	LT / 2 (Min:Max)	73.1 : 73.7 (504 : 508)	62.7 : 83.4 (432 : 437)	11.9 : 12.1

(ASTM E1004)

Conductivity %IACS :	41.8 Min	42.2 Max
(MS/M) :	24.2 Min	24.5 Max

(ASTM E1251)

Chemistry:	SI	FE	CU	MN	MG	CR	ZN	TI	V	ZR	OTHER
Actual	0.08	0.22	1.4	0.02	2.4	0.20	5.7	0.03	0.01	0.01	TOT 0.06

ALLOY LIMITS

Chemistry:	SI	FE	CU	MN	MG	CR	ZN	TI	V	ZR	OTHER	MAX
7075 MIN	0.00	0.00	1.2	0.00	2.1	0.18	5.1	0.00	0.00	0.00	EACH	0.05
MAX	0.40	0.50	2.0	0.30	2.9	0.28	6.1	0.20	0.05	0.05	TOT	0.15

Aluminum Remainder

TEST NOTES

7075-T7351 plate 3.001-3.500" thick, if ultrasonically inspected, meets requirements of CMMPD25 per SDR CMMPD25-KaiserT-1. 7075-T7351 plate 3.501-5.000" thick, if ultrasonically inspected, meets requirements of CMMPD25 per SDR CMMPD25-KaiserT-2.

Metal represented by this test report was immersion ultrasonically tested from one side and meets the Class A and Class B requirements of all specifications referenced on this test report.

CASTLE METALS CORP.
DATE RCVD 12/16/08
IAC 685108
APPROVED BY [Signature]

CERTIFICATION

KAISER ALUMINUM FABRICATED PRODUCTS, LLC (KAISER) HEREBY CERTIFIES THAT METAL SHIPPED UNDER THIS ORDER WAS MELTED IN THE UNITED STATES OF AMERICA OR A QUALIFYING COUNTRY PER DFARS 225.872-1(a), WAS MANUFACTURED IN THE UNITED STATES OF AMERICA, AND MEETS THE REQUIREMENTS OF DFARS 252.225 FOR DOMESTIC CONTENT. THIS MATERIAL HAS BEEN INSPECTED, TESTED, AND FOUND IN COMPLIANCE WITH THE REQUIREMENTS OF THE APPLICABLE SPECIFICATIONS AS INDICATED HEREIN. ALL METAL WHICH IS SOLUTION HEAT TREATED COMPLIES WITH AMS 2772. ANY WARRANTY IS LIMITED TO THAT SHOWN ON KAISER'S STANDARD GENERAL TERMS AND CONDITIONS OF SALE. TEST REPORTS SHALL NOT BE REPRODUCED EXCEPT IN FULL, WITHOUT THE WRITTEN APPROVAL OF KAISER ALUMINUM FABRICATED PRODUCTS, LLC LABORATORY. THE RECORDING OF FALSE, FICTITIOUS, OR FRAUDULENT STATEMENTS OR ENTRIES ON THIS CERTIFICATE MAY BE PUNISHED AS A FELONY UNDER FEDERAL LAW, 18U-9001:2000 CERTIFIED.

BILL POYNOR, LABORATORIES SUPERVISOR

[Signature]

SHIP TO:

A M CASTLE & CO
3400 NO. WOLF ROAD
FRANKLIN PARK, IL 60131

KAISER

ALUMINUM

Trentwood Works - Spokane, WA 99215
Phone: (800) 387-2586

CERTIFIED TEST REPORT

Serial Number

4149447

SOLD TO:

AM CASTLE & CO- SOLD TO
3400 NO. WOLF ROAD
FRANKLIN PARK, IL 60131

CUSTOMER PO NUMBER: 01-15905		WORK PACKAGE:		CUSTOMER PART NUMBER: 6857 A97075-60		SHIP RUN/LOAD ID: 101432/18		GOV'T CONTRACT NUMBER:	
KAISER ORDER NO: 1075544	LINE ITEM: 1	SHIP DATE: 11-DEC-2008	ALLOY: 7075	CLAD: BARE	TEMPER: T7351	PRODUCT DESCRIPTION: MILL FINISH PLATE			
WEIGHT SHIPPED: 5732 LB	QUANTITY: 4 PCS EST.	B/L NUMBER: 2020668		GAUGE: 2.0000 IN		WIDTH: 48.500 IN		LENGTH: 144.500 IN	

Certified Specifications

AMS 4078/RevG
ASTM B 209/Rev07
BSS 7055/RevA
DPS 4.713/RevAH
G8816100/RevG/Amd1

AMS-QQ-A-250/12
ASTM B 594/Rev06
CMMP 025/RevR
EAC MS1011/RevE
MMS 159/RevN

AMS-STD-2154
BAC 5439/RevH
CSTI 008/RevC
GAMP8 9101/RevB
PS 21211/RevK

Test Code: 4297

Test Results

Lot: 456514A9 Cast 198 Drop 21 Ingot 1

(ASTM E8/B557)

Tensile:	Temper	Dir / # Tests	Ultimate KSI (MPA)	Yield KSI (MPA)	Elongation %
	T7351	LT / 2 (Min:Max)	73.2 : 73.8 (508 : 509)	63.6 : 84.9 (439 : 447)	11.6 : 11.8

(ASTM E1004)

Conductivity %IACS :	41.2 Min	41.7 Max
(MS/M) :	23.9 Min	24.2 Max

(ASTM E1251)

Chemistry:	SI	FE	CU	MN	MG	CR	ZN	TI	V	ZR	OTHER
Actual	0.08	0.21	1.5	0.03	2.4	0.19	5.7	0.03	0.01	0.01	TOT 0.05

